

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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OTHER : _____					

Work Order ID 134671

Wednesday, July 15, 2015 9:00:55 AM

134671

Page 3

Item ID: D4154-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Plate

Stop ***NS2***

Start Date: 7/15/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/15/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

LOCATION: WA001

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

JAN 21 2015

MCD

Ⓟ

DQA: _____ Date: _____



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OTHER : _____					

Picklist Print

• Wednesday, July 15, 2015 9:01:00 AM

Work Order ID: 134671

134671

Parent Item: D4154-1

D4154-1

Parent Item Name: Plate

Start Date: 7/15/15

Required Date: 7/15/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

sf

172.9900

5.33

M304S16GA

DL 15/07/15

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT019

172.99

m131384

90

m131503

82.99

5.33

DQA: _____ Date: _____



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OTHER : ☐					

DART AEROSPACE LTD		Work Order: 134621
Description: Plate		Part Number: D4154-1
Inspection Dwg: D4154 Rev: E		Page 1 of 1

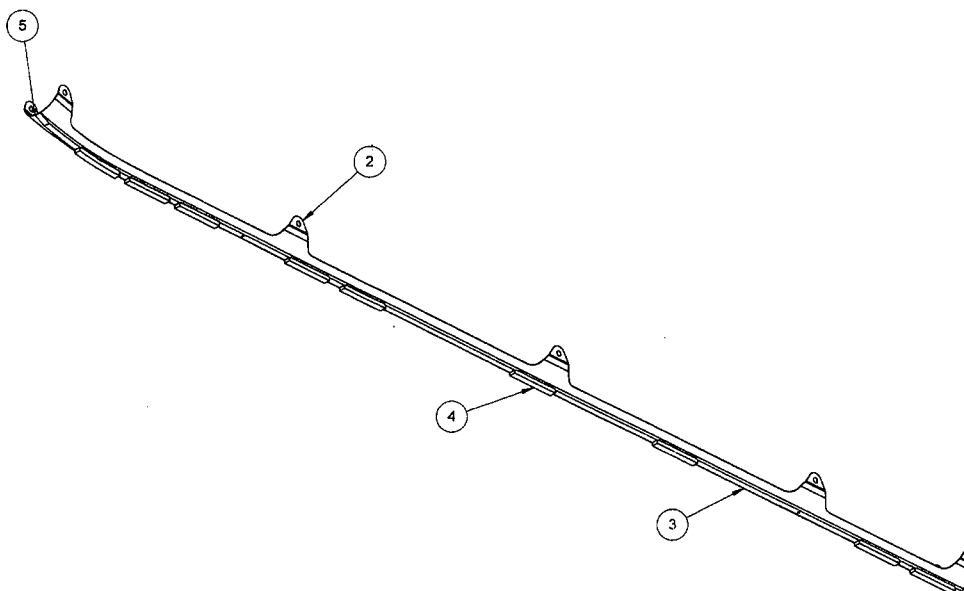
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	.401	/		Vzpc-01	
0.450	+/-0.010	.450	/		Tap	
0.125	+/-0.010	.122	/			
0.38	+/-0.030	.381	/			
0.88	+/-0.030	.881	/			
1.19	+/-0.030	1.192	/			
5.273	+/-0.010	5.271	/			
6.42	+/-0.030	6.423	/			
5.223	+/-0.010	5.222	/			
6.72	+/-0.030	6.721	/			
40.76	+/-0.030	40.76	/			
15.45	+/-0.030	15.45	/			
66.51	+/-0.030	66.51	/			
70.45	+/-0.030	70.45	/			
90.57	+/-0.030	90.57	/			
91.74	+/-0.030	91.74	/			
0.050	+/-0.010	.050	/			
Ø0.516	+0.008/-0.001	.515	/			

Measured by: 12	Audited by:	Preliminary Approval:
Date: 15/07/15	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ	
B	11.04.28	Dimensions updated per Dwg Rev B	KJ	
C	12.05.24	Dimensions updated per Dwg Rev C	KJ	
D	12.07.31	Dwg Rev updated	KJ	
E	12.09.26	Dimensions updated per Dwg Rev E	KJ	

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT2)



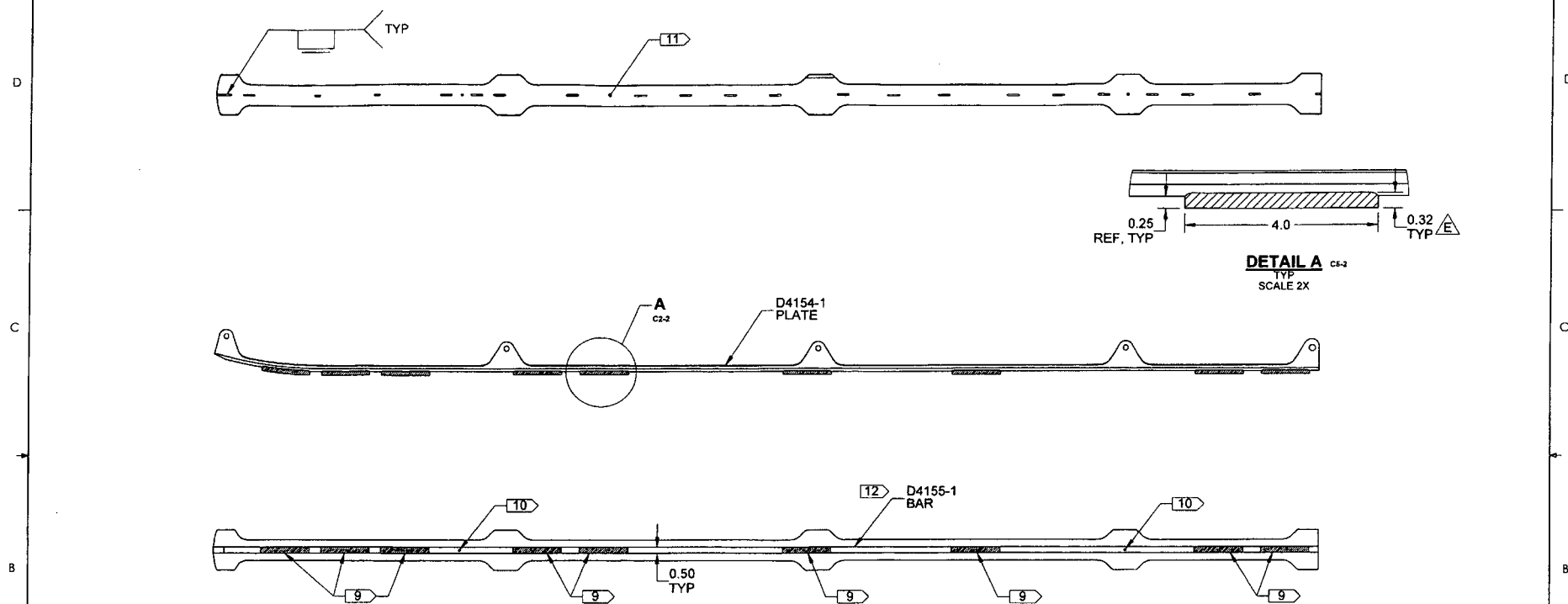
D4154-041 WEARPLATE ASSEMBLY

RELEASED
R 2012-09-04
WP

E	SHT 3 SLOTS RE-PITCHED (PAR 12-213); 0.32 WAS 0.37	AJS	12.08.07
D	70.45 WAS 74.45 & Ø0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2); ADD HARDCOAT (ZN B7-2); ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AJS		
CHECKED	SP	DRAWING NO.	REV. E
MFG. APPR.	IX	D4154	SHEET 1 OF 4
APPROVED	19	TITLE	SCALE
DE APPR.	19	WEARPLATE ASSEMBLY	NTS
DATE	12.08.07	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Handwritten: H B-7-15

8 7 6 5 4 3 2 1



D4154-041 WEARPLATE ASSEMBLY

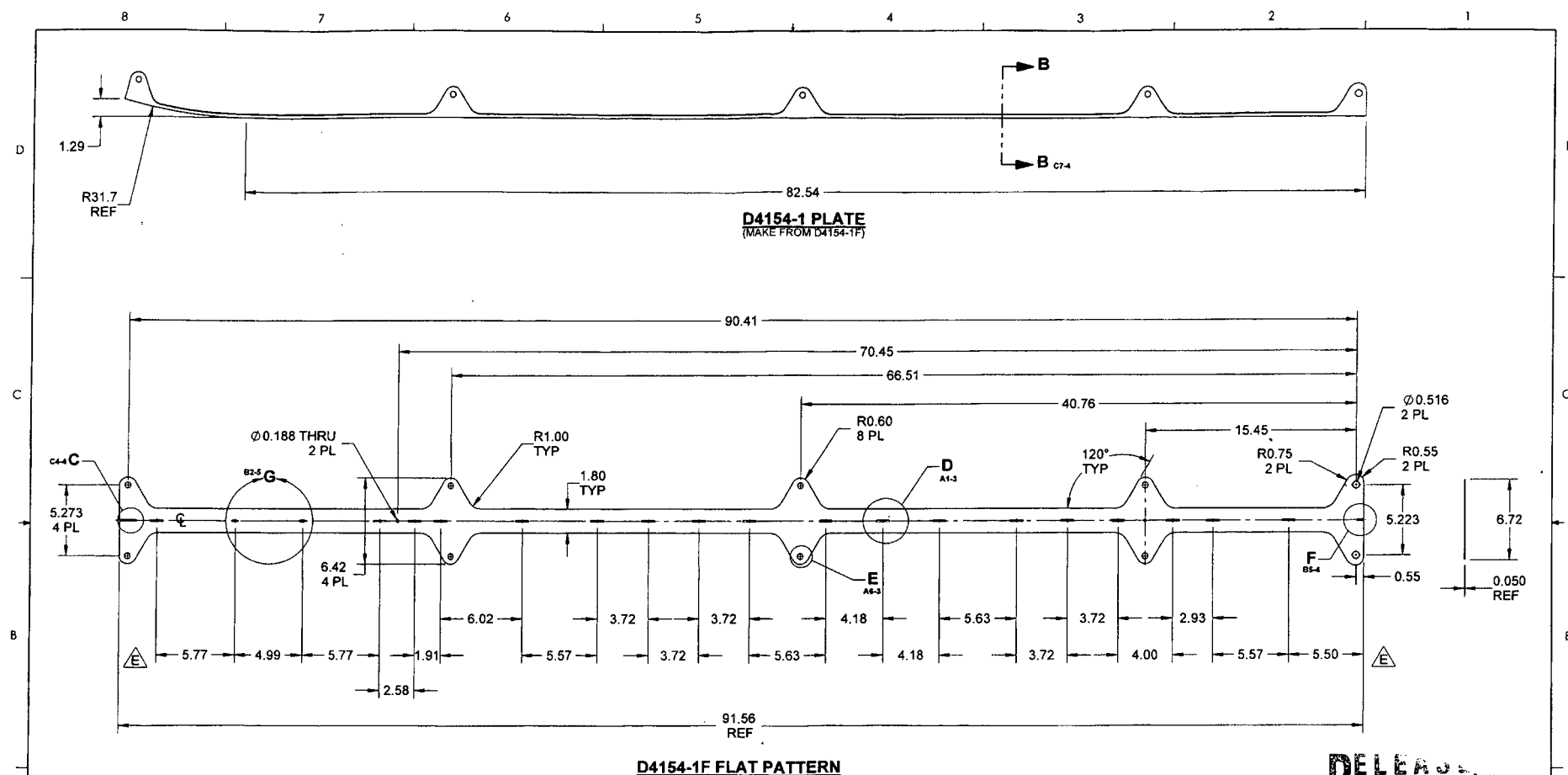
RELEASED
2012-09-01

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 7.75 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	AJS	KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4154	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	12.08.07	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

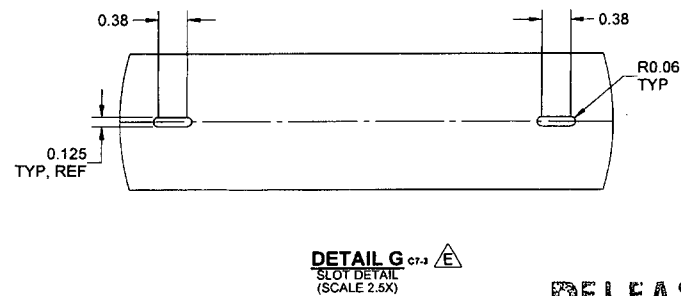
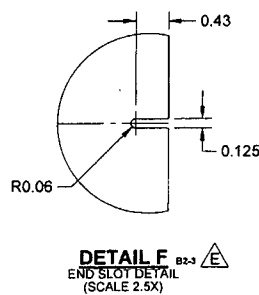
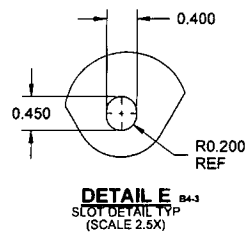
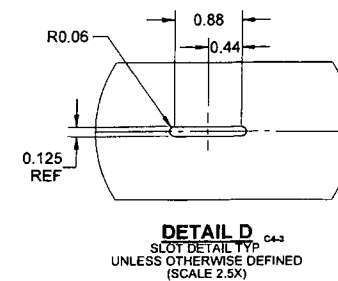
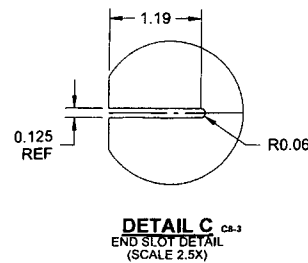
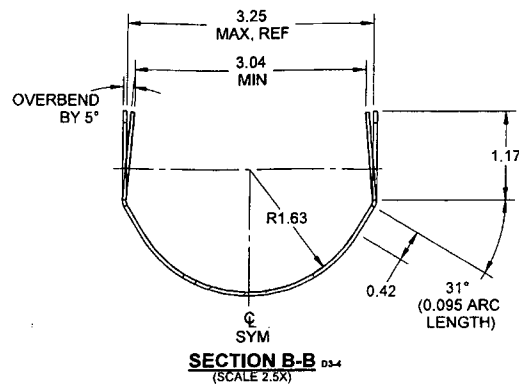


RELEASED
2012-09-04
ND

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.95 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	AJS	KENT, WA	
CHECKED	RP	DRAWING NO.	REV. E
MFG. APPR.	DL	D4154	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	WEARPLATE ASSEMBLY	NTS
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RELEASED
2012-09-04
JW

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DRAWN	AJS	KENT, WA	
CHECKED	SEP	DRAWING NO.	REV. E
MFG. APPR.	DS	D4154	SHEET 4 OF 4
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